



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ASAP

D3204-041
Job Sheet 191312



Part No: D3204-041

Job Qty: 4 pcs

Part Name: Release Pedal Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/27/19

Job Tracking No:

Due Date: 3/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	3/15/19		0.00	5.19	Large Fab - 1		<i>12</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 9	4 pcs	3/15/19		0.00	0.00	QC 9 - 10		DAS 43 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	4 pcs	3/15/19		0.00	0.00	QC 5 - 10		DAS 43 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		DAS 43 9-89
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		



Container No: S161884



Part: D3204 - 041

Job No: 191312

Serial No/Batch: S161884

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/13/19

Plex 2/27/19 7:29 AM Dart.lajeunesse.marie

				QC 5 - 50	
				QC 5 - 30	
130 Handfinish - 1-1 Chemical- B4B	4 pcs	3/15/19	0.00 0.38	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/03/14
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140 Powdercoat - 3 Grey Sand - B4B	4 pcs	3/15/19	0.00 0.30	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BR 19-03-14
				Powdercoat - 4 - B4B	
START: 11:50 O.V.T. 320° FINISH: 12:20					
150 QC 3	4 pcs	3/15/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	DAS
				QC 3 - 36	36
				QC 3 - 41	9-89
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
160 Small Fab - 2 - B4B	4 pcs	3/15/19	0.00 0.27	Small Fab - 1 - B4B	
Plex 2/27/19 7:29 AM Dart.lajeunesse.marie					

170 QC 5	4 pcs	3/15/19	0.00 0.00	Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	DAS
				Small Fab - 4 - B4B	36
				Small Fab - 5 - B4B	9-89
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
180 Packaging 3-1 - Stock - B4B	4 pcs	3/15/19	0.00 0.00	QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	MAR 15 2019 DAS
				QC 5 - 50	40
				QC 5 - 30	9-89
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	GA 119 87 MAR 18 2019
				Packaging 3 - 28 - B4B	MAR 18 2019
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	

190 QC 21 - SA	4 pcs	3/15/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21 MAR 18 2019

Part Op 100 - (Fabricate per Drwg) 1- Pierce a #30 hole center of D3204-5 to let pressure escape while welding. 2- Place parts Descriptions: D3204-1,3,5,13 in jig number DT10295 for tacking parts together. 3- Remove part from jig and install spacing rods to 6" inside of D3204-3 and D3204-5; weld parts then after parts have cooled; remove spacing rods... 4- Inside measurement should be @ 5.9". Then proceed to installing D3204-11 plate, then D3204-9 pedal. 5- Fill #30 hole when parts are cooled to room temperature quickly at around 150 amps...

110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 140 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) ***Cover holes for bushing*** START TIME: OVEN TEMPERATURE:
 FINISH TIME:
 150 - (QC3- Inspect Part Finish)
 160 - (Small Fab)
 170 - (QC5- Inspect part completeness to step on W/O)
 180 - (Identify as per dwg & Stock Location: _____) LOCATION : GA
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3204-1	Tube	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	4/60385
D3204-11	Plate	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5114240
D3204-13	Gusset	8 pcs (2 ea)	100-Large Fab - Welded Assy-1	5109101
D3204-3	Arm	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5096127
D3204-5	Arm	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5156959
D3204-9	Pedal	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5096583
D3204-7	Bushing	8 pcs (2 ea)	160-Small Fab - 2 - B4B	5036911(12) 5137715(20)

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D3204-1	4	16	0
	D3204-11	4	9	0
	D3204-13	8	28	0
	D3204-3	4	8	0
	D3204-5	4	2	0
	D3204-9	4	8	0
	D3204-7	8	24	0
160-Small Fab - 2 - B4B				

Part Specifications	
Specifications could not be found.	

Plex 2/27/19 7:29 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					